206

Work Order ID 91286

October-05-12 9:24:04 AM

91286

Item ID: 647.0410
Revision ID:
Item Name: Tube

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 10/04/12 **Start Qty:** 1.00 *1*
Required Date: 10/31/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLJ **Date:** 12-10-05 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: 647.0400 / N/C									
110		0.00							
110						1	0		FF 13-06-06
Small Fab	**Memo**	0.00							
Small Fab	1- CUT AS PER DWG 2- DEBURR AS PER DWG								
120	QC6- Inspect dimensions to drawing	0.00				1			
120									
QC	**Memo**	0.00							
Quality Control									
130	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
130						CY 13/06/18			(1)
Outsource4	**Memo**	0.00							
Outsource process - Anodize									

B-6-6

P/O: 20215

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 91286

October-05-12 9:24:04 AM

91286

Item ID: 647.0410 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Tube
Start Date: 10/04/12 **Start Qty:** 1.00 *1*
Required Date: 10/31/12 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	**Memo**	0.00							
Packaging							13/7/18		
150	QC's Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160									
SprayPaint	**Memo**	0.00							
Spray Painting	PRIME AS PER DWG CARDINAL 4860-50 PRIMER BATCH: 125452						CZ 13/06/18		

N/A

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Other

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Work Order ID 91286

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Item ID: 647.0410 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Tube

Start Date: 10/04/12 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 10/31/12 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00				1			
170									
QC	**Memo**	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 5538	0.00							
180									
Packaging	**Memo**	0.00				1X			SD 13-7-18
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00				MLJ 13-07-19			
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
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☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Picklist Print

October-05-12 9:24:03 AM

Work Order ID: 91286
Parent Item: 647.0410
Parent Item Name: Tube

Start Date: 10/04/12 **Required Date:** 10/31/12
Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 12.09.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.035 6061-T6 ROUND TUBE 1" X .035" WALL		Purchased	No			110	f	7.5000	**0.4275**	**0.45**	FF 13-0606		

Location	Loc Qty	Loc Code	
MAT035 124694	7.5		0.45
123010	7.5		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Work Order Update ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
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☐ Wrong Stock Pulled

☐ Other

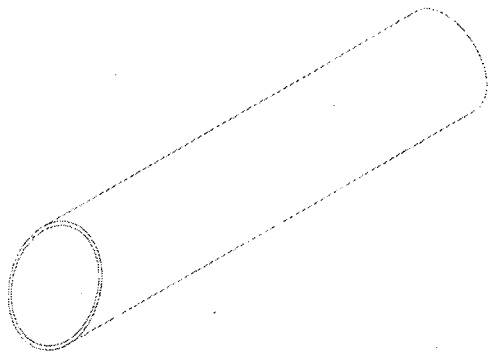
_____
_____
_____

THE INFORMATION CONTAINED BY THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

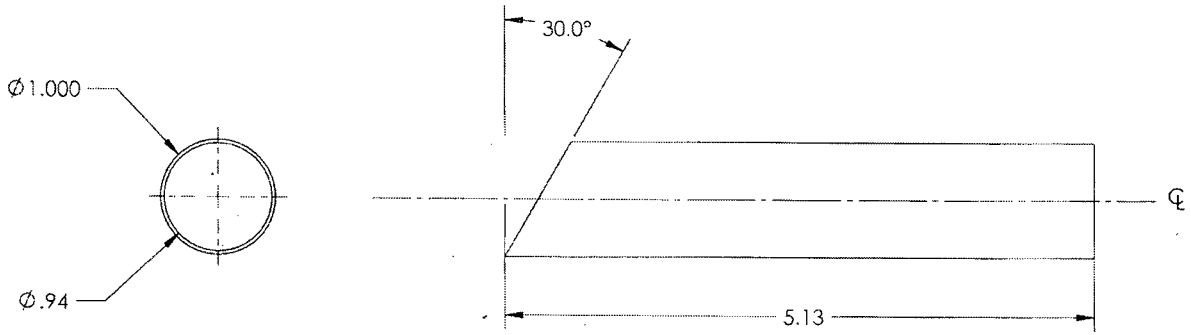
REV	ISSUE POINT	DATE	APPROVED
	LAST PRODUCTIVE REVISION PER		ENG
ENG	INITIAL RELEASE	04/28/97	P. BRAVO

NOTES:

1. MATERIAL: 6061-T6 ALUMINUM IAW AMS-4080
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
   CARDINAL 4860-50 PRETREATMENT PRIMER
   PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.0410



FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	647.0410	TUBE		

QTY

PARTS LIST

NEXT ASSY (S)

646.9500

DRAWN BY: DATE: 04-28-97 | CHECKED: P. BRAVO | ENGINEER: S. HUNT | DRAWING APPROVAL: PB | QA/REL: | CONTRACT NO.:

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 3 PLACE DECIMALS ±.01, 5 PLACE DECIMALS ±.005, ANGLES ± 2°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

TUBE

SIZE: 6 | CAGE CODE: 07MZ6 | DWG NO: 647.0400 | REV: N/C

SCALE: NONE | SHEET 1 OF 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 91286 MLS
12-10-05

A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62506 Date: 15-Jul-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200 Fax: 613-632-1185

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200 Fax: 613-632-1185

Terms	Ship Via

Quantity	Description
1 lot	Part: ASST Rev: 6 PCS D2224 RED ANODIZE MIL-A-8625 TYPE II CLASS 2 1 PC 647.0410 10 PCS 646.3110 20 PCS 646.3712 11 PCS 646.3713 8 PCS 647.9312 30 PCS 647.9313 9 PCS 647.9314 1 PC 647.9317 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130436 PO: 20215 Line:

Certificate of Conformance

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE : 15/7/13

CERTIFIED SIGNATURE : _____

RECEIVER SIGNATURE : _____